

Work Order ID 55927

February 4, 2010 2:40:05 PM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 2/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *RF*

Date: *10-20-04*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 005

8/10/03

B55927

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 & DT8863 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"

5- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.

6-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".

8-Open up holes of Detail J to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/RJHJ Aluminum Rod

m11-3207

10-Grind welds flush as per Dwg D2750

M 10/2/08

BB 10/2/08

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Reference:

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Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11- scribe batch #.

BE 10/02/08

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

2) 8/10/08

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

2) 8/10/08

⑩

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

BE 12/02/09

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP 10-2-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐ ☐ ☐ Sikaflex-291

batch: 2112429

exp. date: 10/8/30

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R ☐ ☐ ☐ Aluminum Rod

batch: M1L3207

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

BE 10/02/09

DP 10-2-9

BE 10-2-10

DP 10-2-17

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11- At section AJ-AJ drill out x-bolt spacer to 0.404"

BE 10/02/10

12-Debur holes

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8.10/02/10

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8.10/02/10

(to)

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

TOUCH-UP ALLOWED
Memo

0.00

Hand Finishing

BR 10-02-18

0-

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME: 11:00 AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 11:30 AM

0.00

=> 10/02/18

(X) 0

210

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

Inspect for foreign object per QSI 024

0.00

BR 10-02-26

0

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220



HandFinish
Hand Finishing

HandFinishing

Memo

Install inserts as per dwg D2750

0.00

0.00

=7 HU 10/02/26

(YI)

Ø

230



HandFinish
Hand Finishing

HandFinishing

Memo

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3"
batch: M12

✓ 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as
per dwg D2750
SIKA FLEX 241
BATCH: M112345
EXP DATE: 10/09

✓ 4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube
A/R 55-o-ring lube batch: M101223

✓ 5-Coat all exposed fasteners with "LPS Procyon"
batch: X1104251

0.00

0.00

HU 10/02/26

(YI)

Ø

W/O:		WORK ORDER CHANGES					
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Work Order ID 55927

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Setup Start



Revision ID:

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Start Date: 2/04/10 Start Qty: 1.00



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Required Date: 2/12/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/12/01

Memo

0.00

250



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

10-3-2

S

260



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

S 10/12/03

Memo

0.00

40

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling: Date:

Stop



QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270



Packaging

Packaging

0.00

Memo

0.00

Packaging

Package as per PPP D350-636-012

Rev H

10-3-4 SD

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/05 AJ

ME
10-3-4

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 55927

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 102.09.25 Rearranged procedure steps I KJ
IPP Rev: J 06-03-29 As per Rev D EC
IPP Rev: K 06-07-13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225 Purchased No 220 Each 6,420.000 38.0000



Insert

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

6420

107441

16

110768

6404

AN3C5A Purchased No 230 Each 706.0000 34.0000



Bolt

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

706

111424

8

111707

69

112314

1

113121

214

113149

300

113644

114

y38 10/02/26

y34 10/02/26

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Skidtube RH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: L 02-09-25 Rearranged procedure steps F'KJ
IPP Rev: J 06-03-29 As per Rev D EC
IPP Rev: K 06-07-13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 778.0000 4.0000



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

778

111982

778

X4 10/02/26

AN6C44A Purchased No 230 Each 116.0000 4.0000



BOLT

Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG

2

103964

2

Main Warehouse

ST

114

110105

4

110155

14

110665

1

111605

42

111649

50

112720

1

113121

2

X4 10/02/26

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Shop Packet Print

Page 2

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 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN8C35A Purchased No 230 Each 131.0000 1.0000



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

131

102180

1

106896

1

110105

48

110847

81

x1 10/02/26

AN960C10L Purchased No 230 Each 388.0000 38.0000



washer

XNAS 1149C6 332R

Warehouse Loc Qty Loc Code

Location

OFFSHORE

M 113737

FG

100

103585

100

Main Warehouse

ST

288

112116

128

112612

160

x38 10/01/26

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Shop Packet Print

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IPP Rev: J 06-03-29 As per Rev D EC
IPP Rev: K 06-07.13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased

No

230

Each

216.0000

1.0000



WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

216

104093

2

107520

4

110139

29

110584

100

11424

81

x1 21 10/02/26

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Shop Packet Print

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Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
IPP Rev: J 06-03-29 As per Rev D EC
IPP Rev: K 06-07.13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No 230 Each 298.0000 8.0000



Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 36

43754 2

44893 33

45556 1

Main Warehouse

ST023 23

34817 2

36230 8

37303 1

39587 2

40726 2

41114 2

42778 6

Main Warehouse

ST46 239

51537 54

51910 4

52311 181

x8 41 10/02/26

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55927



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: [] 02.09.25 : Rearranged procedure steps [] KJ []
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3488-042 Manufactured No 230 Each 13.0000 1.0000



Blade Fitting Assembly, RH

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 13

29043 1

52666 12

D3492-041 Manufactured No 230 Each 121.0000 8.0000



Plug Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 121

51584 44

5446 77

X1 10/02/26

X4 10/02/26
 X4 10/02/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55927



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev:J 02.09.25 Rearranged procedure steps I KJ
IPP Rev:J 06-03-29 As per Rev D EC
IPP Rev:K 06-07.13 As per dsi9343 EC
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

D3492-043 Manufactured No 230 Each 95.0000 8.0000



Plug Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

91

54682

91

Main Warehouse

ST

4

52309

4

D3535-25 Manufactured No 230 Each 8.0000 1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

2

51927

2

Main Warehouse

ST

6

52589

6

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55927



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02-09-25 Rearranged procedure steps [JKJ]
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07-13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3536-25 Manufactured No 230 Each 33.0000 1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP10	28	
51607	2	
54479	26	
Main Warehouse		
ST	5	
45569	1	
47011	2	
47526	2	

xl 44 10/02/26

D3537-1 Manufactured No 230 Each 90.0000 3.0000



Wearpad

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	2	
48288	2	
Main Warehouse		
FP17	88	
51678	1	
51679	87	

xl 44 10/02/26

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55927



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3631-1 Manufactured No 230 Each 394.0000 8.0000



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	394	
52693	94	
54388	300	

y8 H 10/02/26

D3672-1 Manufactured No 230 Each 1,720.000 4.0000



Phenolic Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1220	
39275	19	
42329	5	
47628	196	
52505	1000	
Main Warehouse		
ST117	500	
51674	500	

y4 H 10/02/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55927



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 102.09.25 [Rearranged procedure steps] [KJ]
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No 230 Each 5.0000 1.0000



Wearplate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

2

51610

2

Main Warehouse

ST

3

51909

3

X1 24 10/02/26

D3793-1 Manufactured No 230 Each 15.0000 1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

15

40551

1

51597

14

X1 24 10/02/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55927



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps I KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07-13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3793-3 Manufactured No 230 Each 10.0000 1.0000



Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

10

51592

10

D3794-1 Manufactured No 230 Each 21.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP

18

51928

6

55459

12

Main Warehouse

ST

3

46530

1

47212

2

VI 10/02/26

VI 10/02/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55927



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07-13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3794-3 Manufactured No 230 Each 15.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

B 56066

Y1 JB 10/02/26

FP

12

51598

2

51907

10

Main Warehouse

ST

3

46531

2

47440

1

MS21043-6 Purchased No 230 Each 976.0000 4.0000



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

976

112314

976

Y4 JB 10/02/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55927



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

MS21083C8 Purchased No 230 Each 78.0000 1.0000



NUT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	78	
110584	5	
111424	2	
113149	21	
113845	50	

41 JH 10/02/26

NAS1611-010 Purchased No 230 Each 330.0000 8.0000



O-RING

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	330	
110715	44	
110915	286	

* PTO =>

W/O: 55927		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/02/26	230	Replace "O" Rings NAS1611-010 for "O" Ring D2594-3 / B52262	HJ	10/02/26	X8		SJ 10/02/26

Part No: D350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55927



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: [1] 02.09.25 [1] Rearranged procedure steps [1] KJ [1]
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased No

230

Each

142.0000

8.0000



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

100

113743

100

Main Warehouse

ST

42

106513

11

111424

20

111758

11

AN8C21A

Purchased No

250

Each

130.0000

2.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

130

105160

1

107596

1

107924

2

109092

2

110341

2

110342

2

111605

50

112720

20

113558

50

Y8 10 10 (02) 26
 10-3-2 50

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55927



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: 02.09.25 [Rearranged procedure steps] KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased

No

250

Each

216.0000

2.0000



WASHER



10-3-2 SD

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

216

104093

2

107520

4

110139

29

110584

100

111424

81

D2741

Manufactured

No

250

Each

24.0000

1.0000



Blade, 350 Skidtube



10-3-2 SD

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

24

51931

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55927



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02-09-25 Rearranged procedure steps [1] KJ [1]
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07-13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3493-1 Manufactured No 250 Each 41.0000 2.0000



Washer

10-3-2 SD

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 41
 44902 2
 47710 39

D3532-1 Manufactured No 250 Each 68.0000 2.0000



Spacer

2

10-3-2 SD

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 68
 44904 2
 52321 66

D3672-13 Purchased No 250 Each 934.0000 2.0000



Phenolic Washer

2

10-3-2 SD

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 934
 54363 934

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55927



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps (KJ)
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased No

250

Each

78.0000

2.0000



NUT

10-3-2 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

78

110584

5

111424

2

113149

21

113845

50

2

D2600-3-BENT

Manufactured No

110

Each

17.0000

1.0000



Extrusion Bent

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

12

50675

2

55462

10

Main Warehouse

ST

5

43495

1

47133

1

52346

3

1 11/2/8

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55927



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps (KJL)
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2744 Manufactured No 110 Each 51.0000 1.0000



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 51

44892 1

47488 23

51922 27

D2739 Manufactured No 160 Each 5.0000 1.0000



350 I Beam

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 5

47124 1

53900 2

55034 1

55569 1

B55980

①

DP 10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55927



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 102.09.25 Rearranged procedure steps. I KJ I
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 160 Each 227.0000 8.0000



Crossbolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG 52

50281 50

51913 2

Main Warehouse

ST 175

44891 2

45555 17

48275 1

52310 155

8 EC 10/02/10

D3490-3 Manufactured No 160 Each 69.0000 4.0000



Cross Bolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG 60

55010 60

Main Warehouse

ST 9

45560 1

48276 4

51930 4

4 BE 10/02/10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 20

February 4, 2010 2:39:59 PM

Work Order ID: 55927



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps [KJ]
IPP Rev: J 06-03-29 As per Rev D EC
IPP Rev: K 06-07.13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00


Required Qty: 1.00

D3490-1 Manufactured No 160 Each 52.0000 4.0000



Cross Bolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	52	
45338	2	
47657	2	
48277	9	
51932	39	


4 2E 10/22/10

February 4, 2010 2:39:59 PM

Shop Packet Print

Page 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RAH		
CHECKED	RAH	DRAWING NO.	REV. F
MFG. APPR.	RAH	D2750	SHEET 1 OF 11
APPROVED	RAH	TITLE	SCALE
DE APPR.	RAH	350 SKIDTUBE ASSEMBLY	NTS
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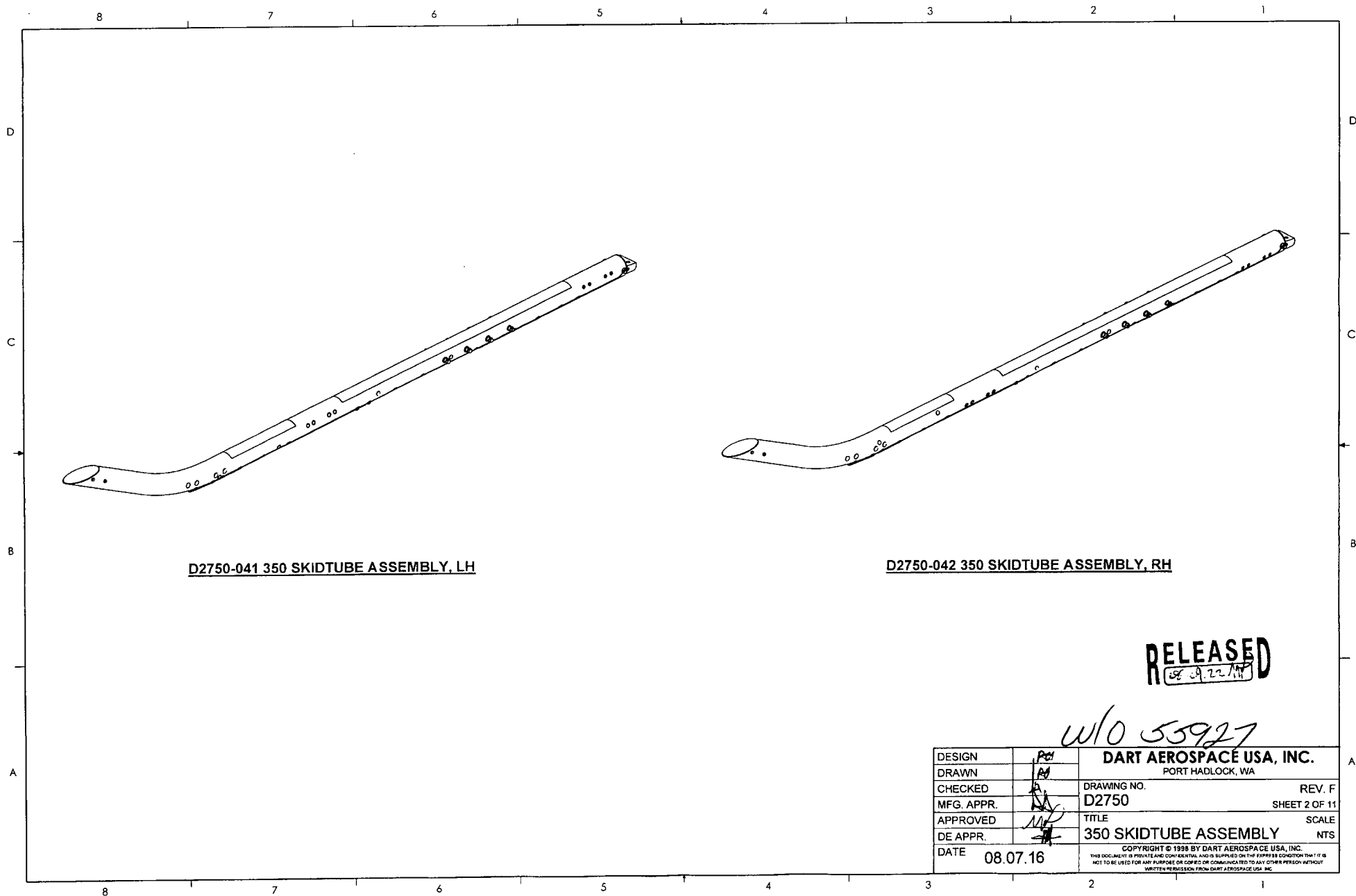
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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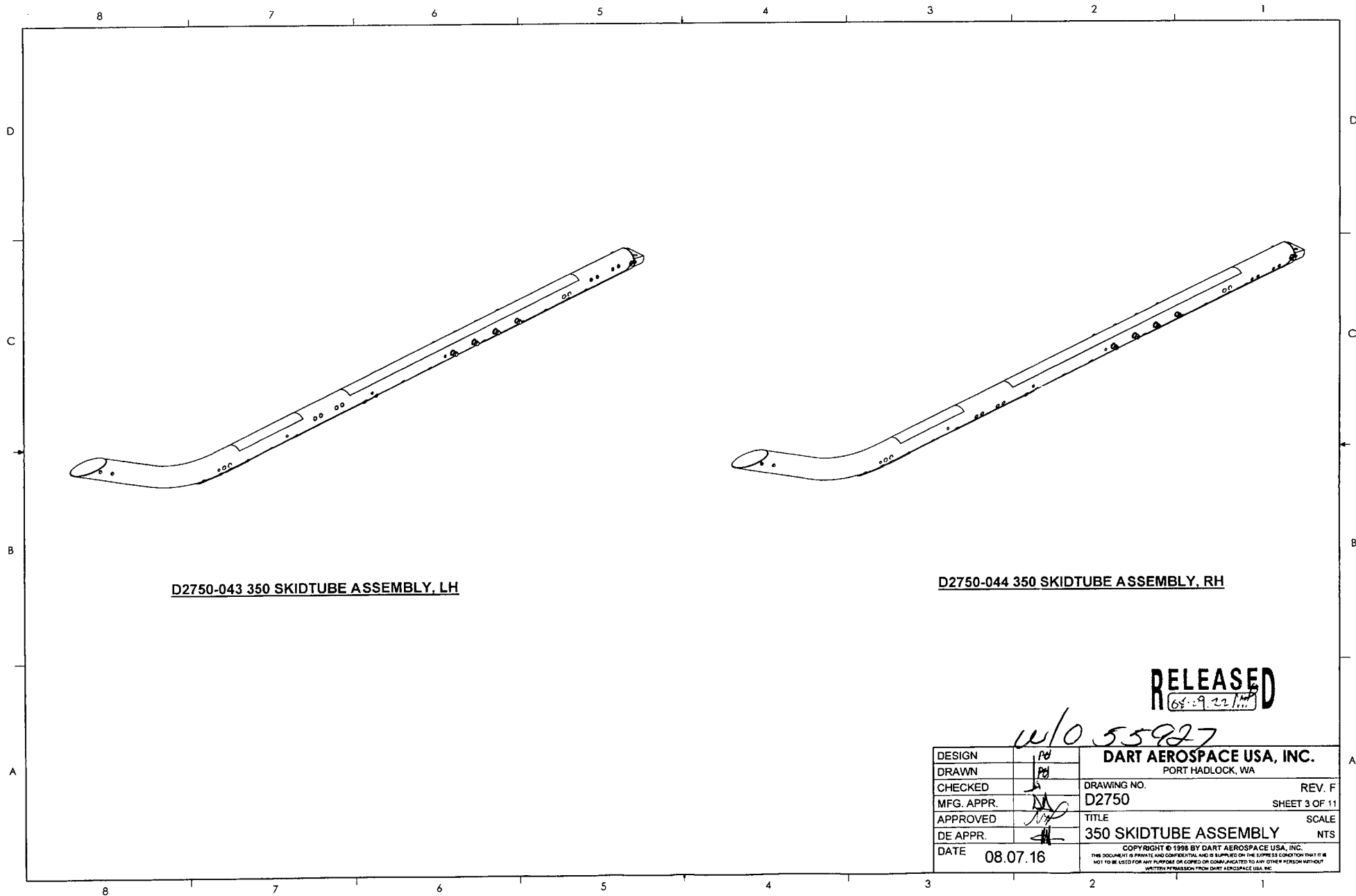
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D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

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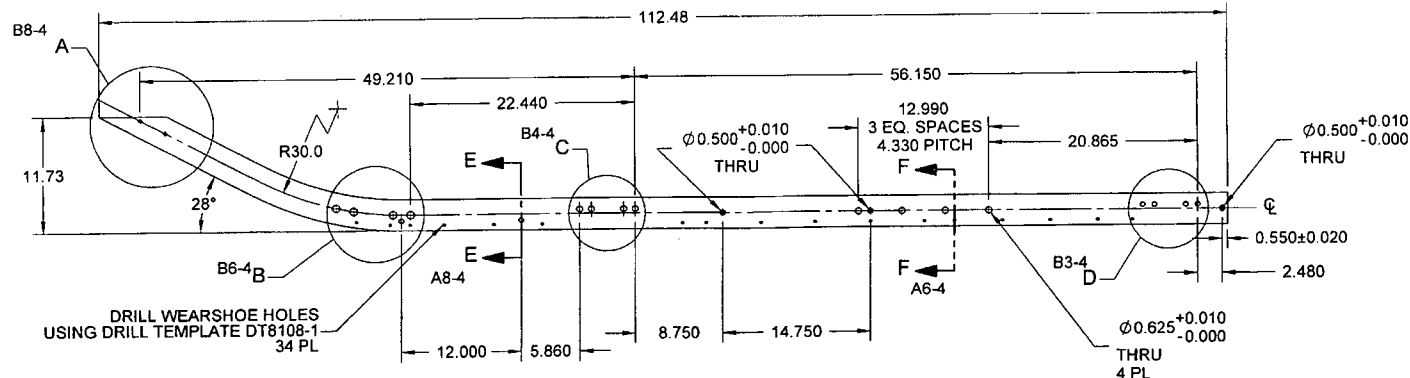
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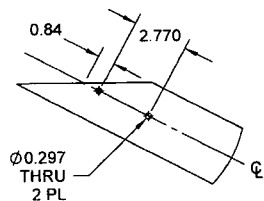
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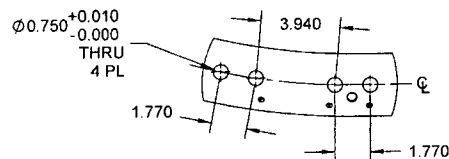
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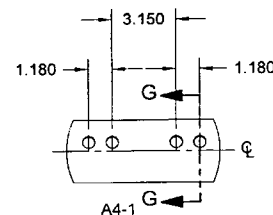
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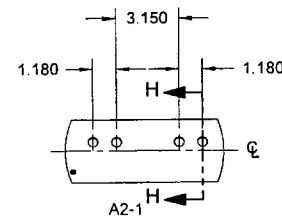
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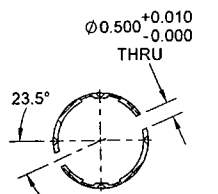
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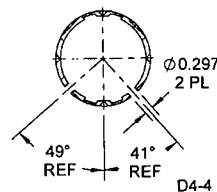
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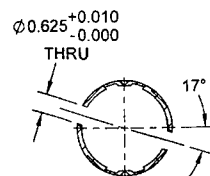
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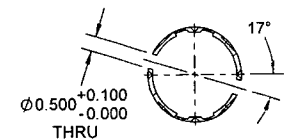
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SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
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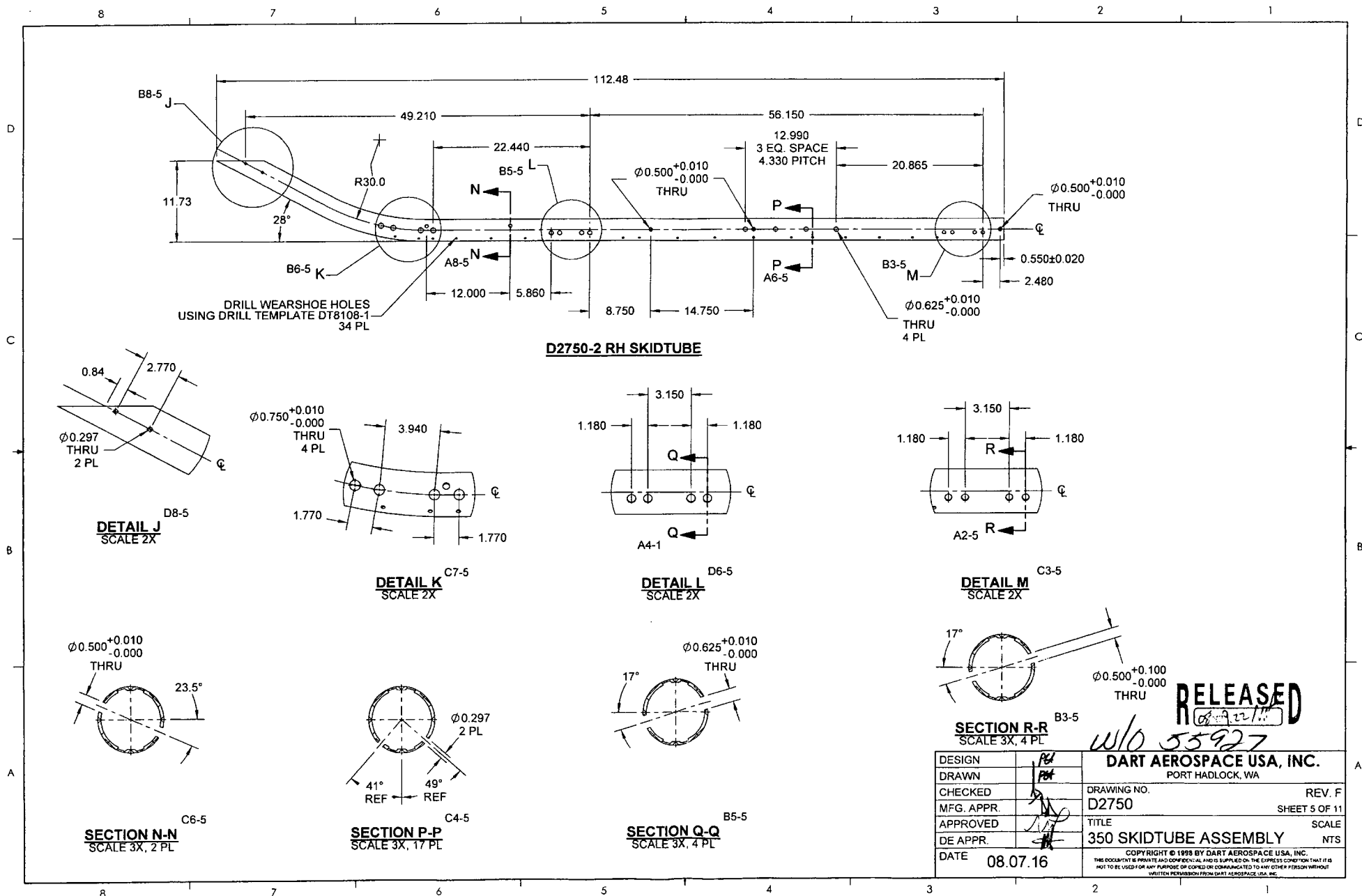
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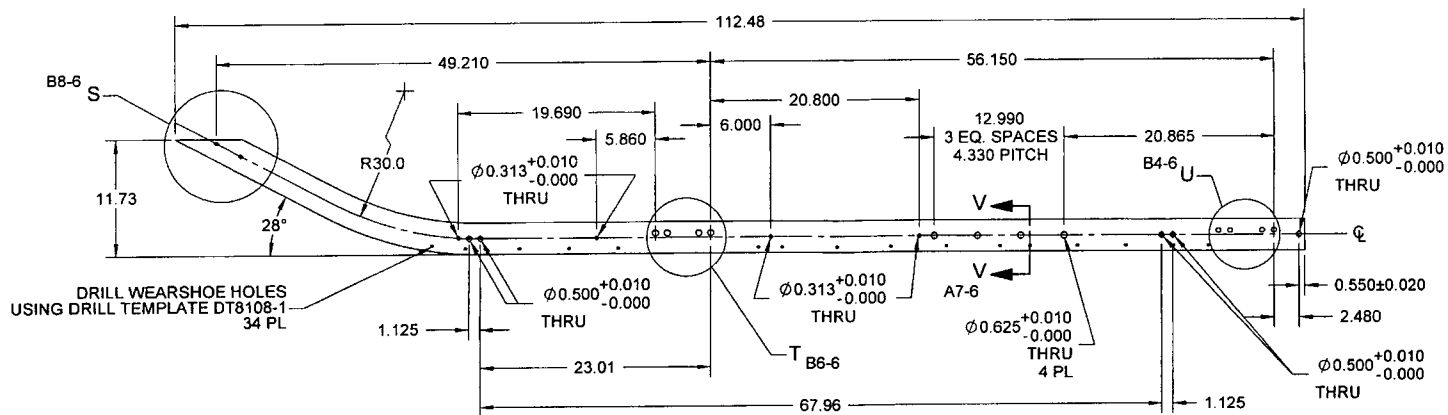
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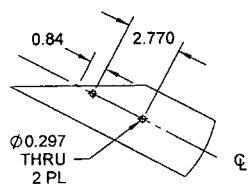
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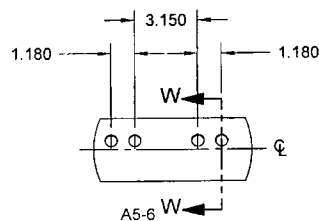
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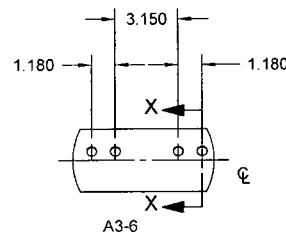
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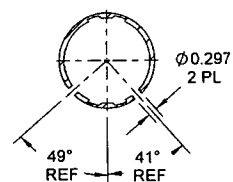
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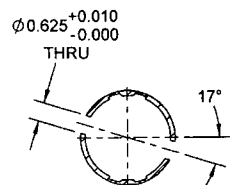
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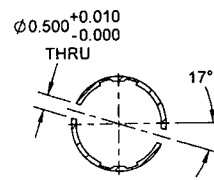
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D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B6-6
SCALE 3X, 4 PL



SECTION X-X
B4-6
SCALE 3X, 4 PL

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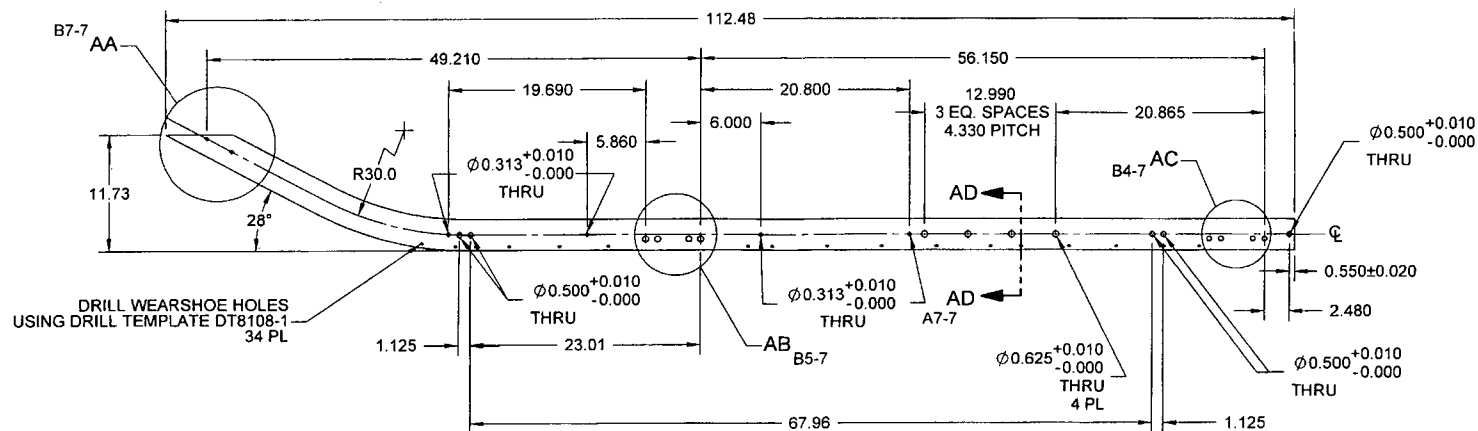
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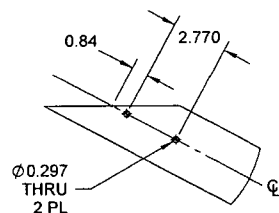
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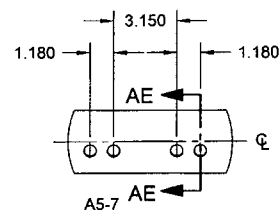
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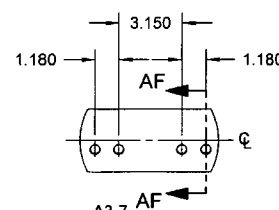
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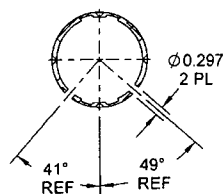
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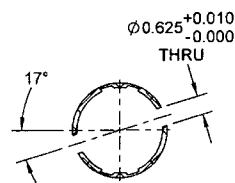
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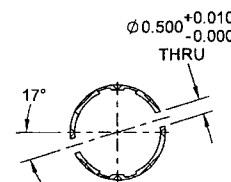
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SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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06-09-22-117

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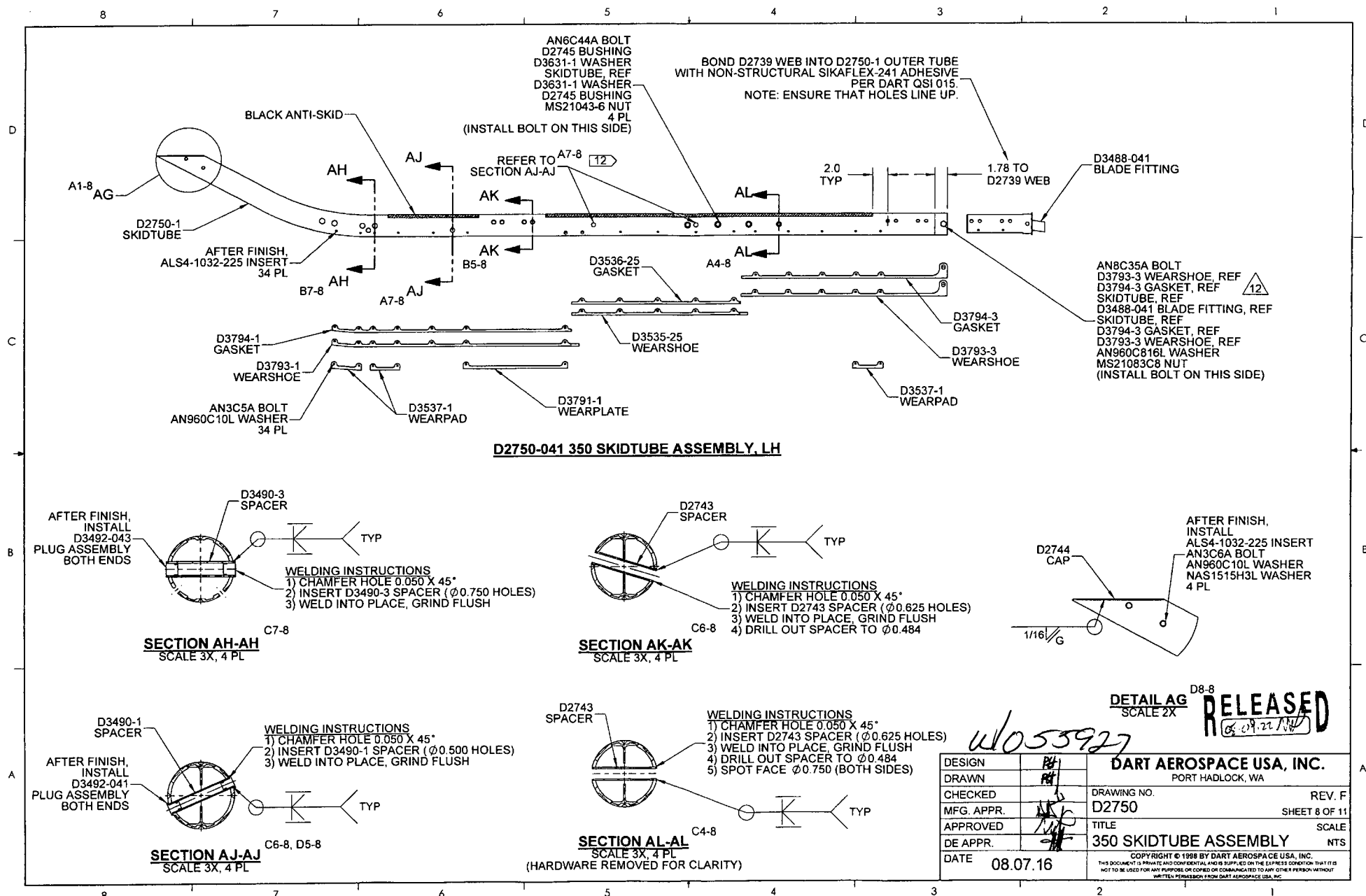
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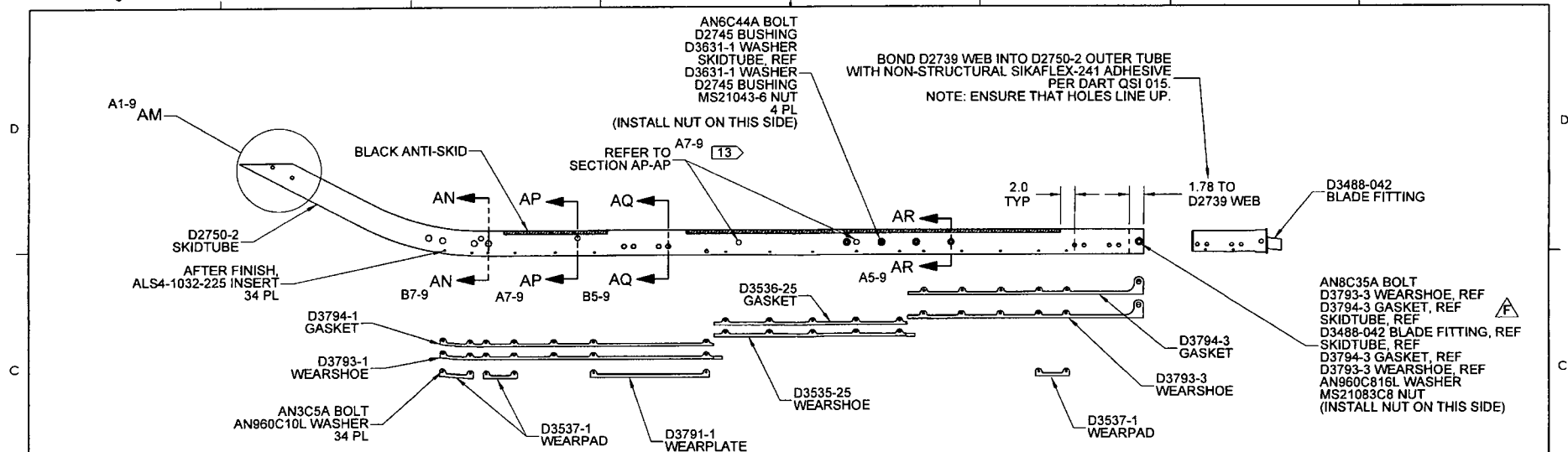
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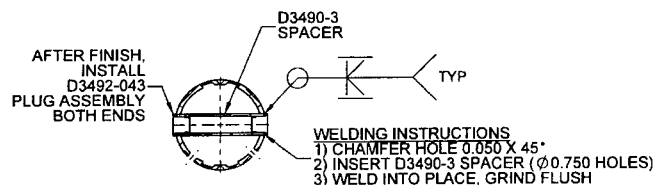
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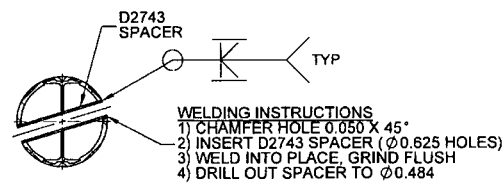
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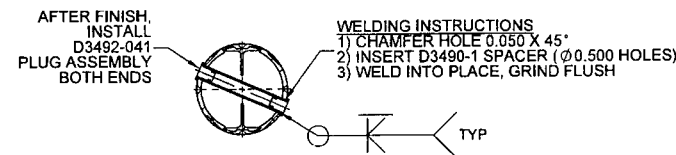
D2750-042 350 SKIDTUBE ASSEMBLY, RH



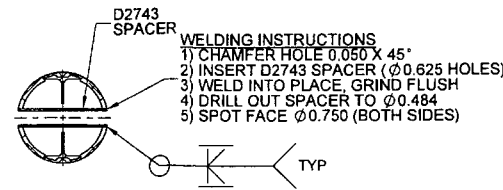
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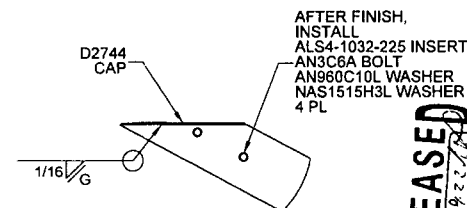
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SCALE 3X, 4 PL



SECTION AP-AP
SCALE 3X, 4 PL



SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL AM
SCALE 2X

DESIGN	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D2750 TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS <small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>
DRAWN	PH	
CHECKED	AC	
MFG. APPR.	MD	
APPROVED	MD	
DE APPR.	MD	REV. F
DATE	08.07.16	SHEET 9 OF 11

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W/O 55927

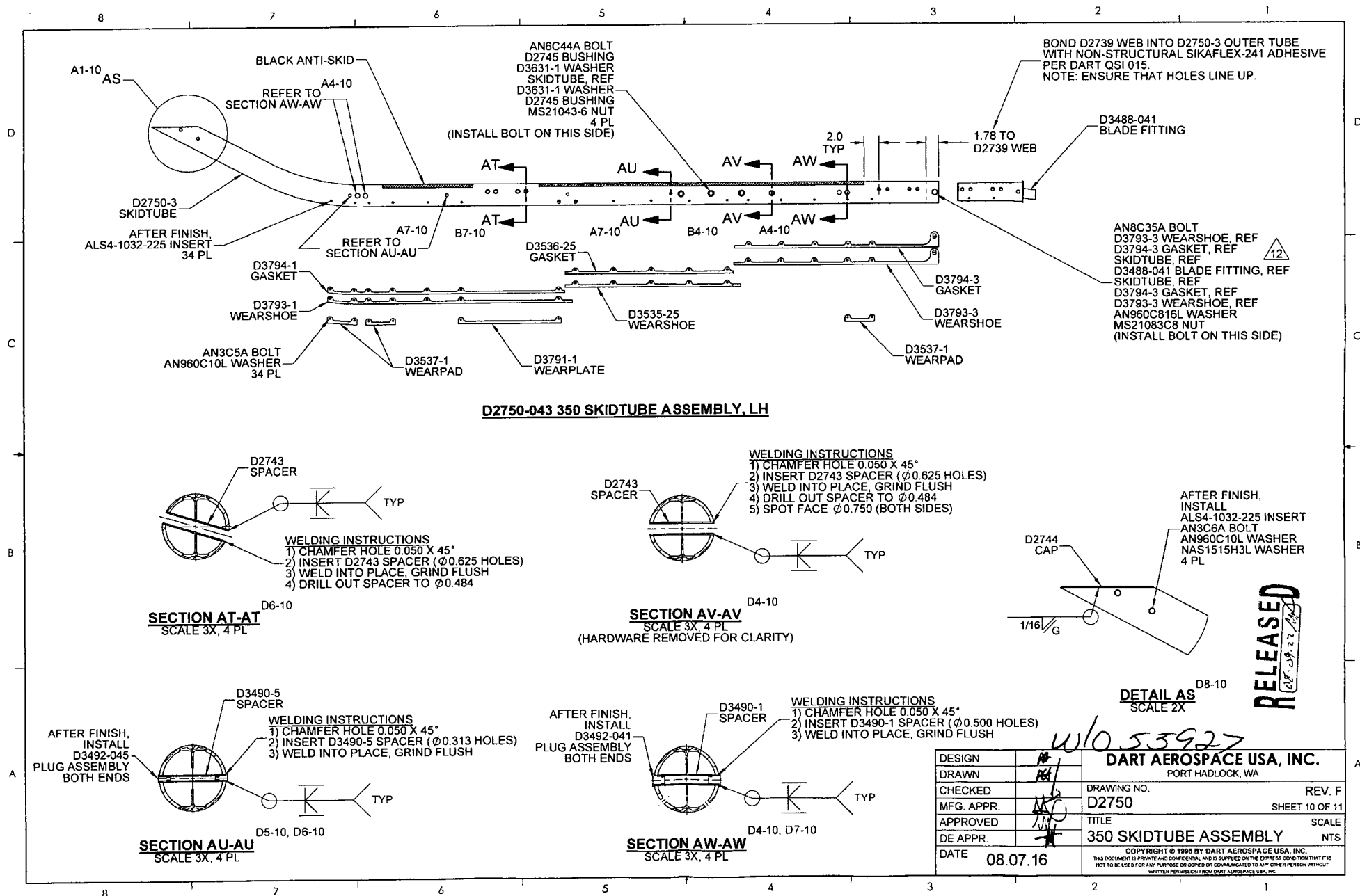
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

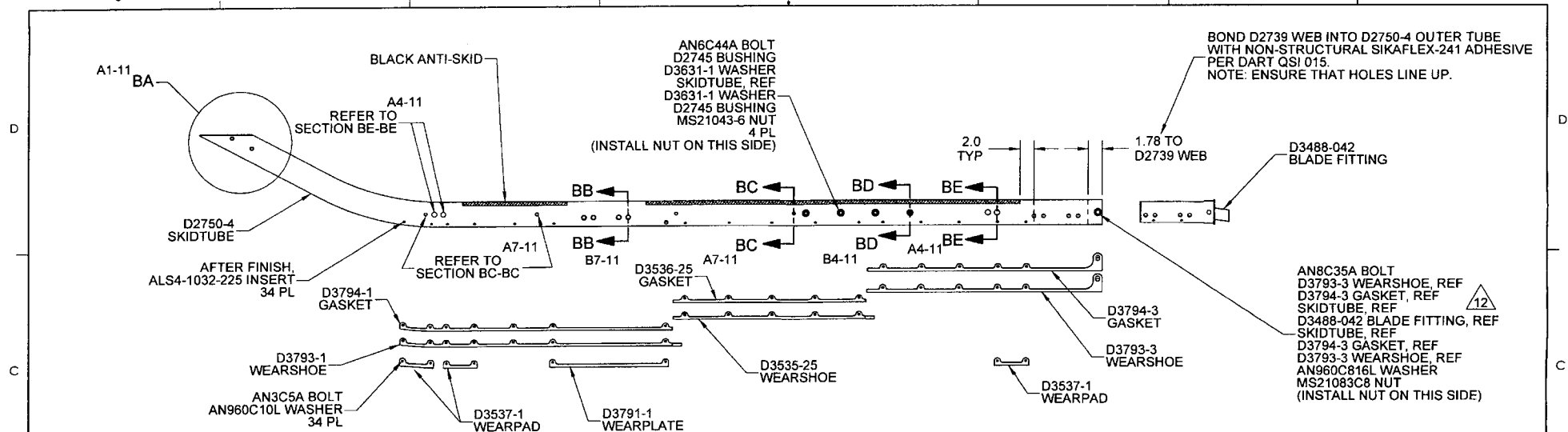
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

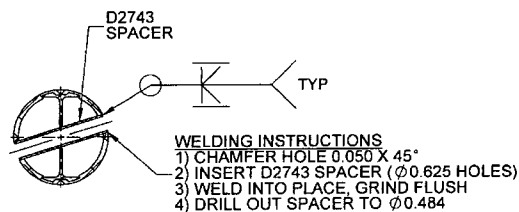
NOTE: Date & initial all entries

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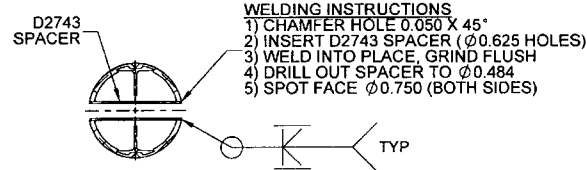


D2750-044 350 SKIDTUBE ASSEMBLY, RH

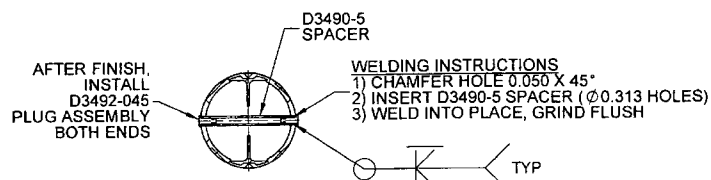
RELEASED
08.07.16



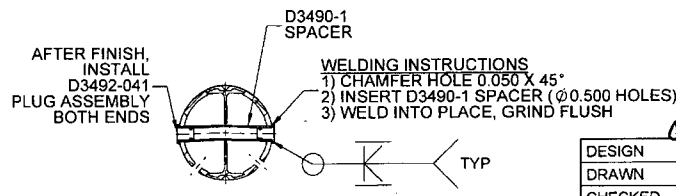
SECTION BB-BB
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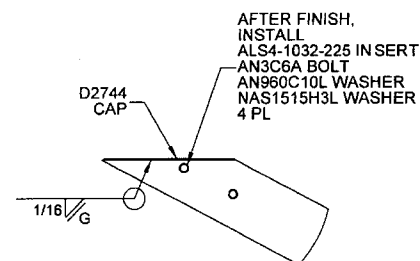
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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CHECKED	PH	DRAWING NO.	REV. F
MFG. APPR.	PH	D2750	SHEET 11 OF 11
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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